

# Work Order ID 75077

October-17-11 10:50:09 AM

**\*75077\***

Page 1

Item ID: D2810-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Strut  
 Start Date: 17/10/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 28/10/2011 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/17 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2810	Rev C								

100 NC BRAKE 0.00  
**\*100\***  
 Brake NC Memo 0.00  
 Brake NC 1-Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per SB 11/10/08  
 Dwg D2810 and spec control Dwg D2727 using Jig DT8012 cut at 24.060  
 2-Deburr 10  
Ac 11.11.04 X10

110 QC5- Inspect part completeness to step on W/O 0.00  
**\*110\***  
 QC Memo 0.00 5 11/11/25  
 Quality Control X10

120 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00  
**\*120\***  
 Powdercoat Memo 0.00  
 Powder Coating START TIME: 1:45  
 OVEN TEMPERATURE: 320°F  
 FINISH TIME: 2:15  
W115128 10X Ø M-L 11/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75077

**\*75077\***

Page 2

October-17-11 10:50:09 AM

Item ID: D2810-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Strut  
 Start Date: 17/10/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 28/10/2011 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <b>8005</b>	0.00							
<b>*140*</b>									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

10. **BL** 11-11-28.

**(10x)** SP 11-11-28.

11/11/29 **[Signature]**

SMF 11-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-17-11 10:50:13 AM

Page 1

Work Order ID: 75077

**\*75077\***

Parent Item: D2810-5

**\*D2810-5\***

Parent Item Name: Strut

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A04.11.30New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	183.6323	1.9175	20.18421			

**\*M304TR0 500W 035\***

304 RD Tube .500 x .035W

**\*\***

*Ac 11.11.04*

Location

Loc Qty

Loc Code

MAT017

183.6322723

115535

2.33

116720

1.66068

117598

22.6415923

118702

57

119160

100

20.1842

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

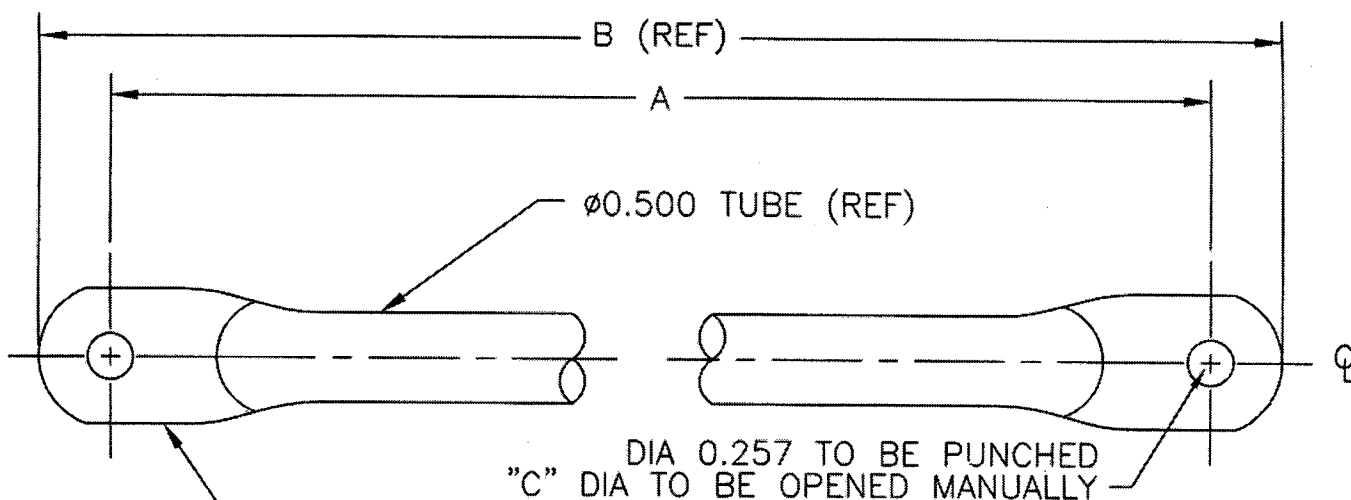
**NOTE:** Date & initial all entries



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2810	REV. C SHEET 1 OF 1
DATE 04.11.22		TITLE STRUT	SCALE NTS
A	00.11.08	NEW ISSUE	
B	03.09.11	ADD FINISH	
C	04.11.22	ADD -5	

RELEASE

05.03.11 *[Signature]*



PUNCH ENDS PER  
SPEC CONTROL  
DRAWING D2727

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25077

PART #	A	B	C
D2810-1	25.33	26.13	N/A
D2810-3	24.60	25.40	N/A
D2810-5	23.01	23.81	0.266

*11-10-17*

D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE,  $\phi 0.500 \times 0.035$  WALL (M304TR0.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.